

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000706**Date Inspected:** 23-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	n/a			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** Angle and Slot Beam**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Quality Assurance (QA) Inspector, Sherri Brannon worked on setting up notebooks and filing submittal's, state letter's of approval and welding quality control plan addendums (WQCP). Also, worked on updating spreadsheets and creating tracking logs for tracking various QA, Office of Structural Materials (OSM) functions.

**Inspection of Shape Material:**

Quality Assurance (QA) Inspector Brannon received shape (angle and slot) material list for the 89 Meter mock-up received from American Bridge/Fluor (ABF). QA Inspector Brannon went to the ZPMC material storage yard accompanied by ZPMC Quality Assurance Mr. Tao Lei. QA Inspector Brannon performed visual verification of a total of 5 shapes for 89 Meter mock-up. The shapes were observed for their identification tags, general condition and markings. Shape material thicknesses range from 8mm to 14mm. The shapes were designate Grade Q235B. Shape material list for 89 Meter mock-up was accompanied with material test reports (MTR's) RFI ABF-RFI-000556R00: subject: Rolled Shapes substitution for mock-ups.

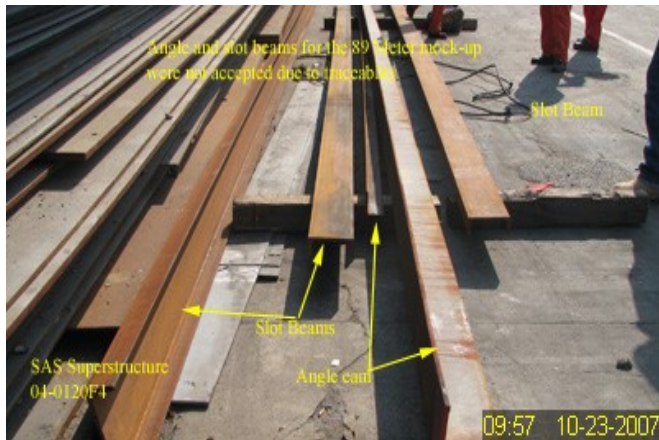
NOTE:QA Inspector Brannon did not assign a lot number to the shapes due to when identifying the material was missing traceability identification markings for the angle and slot (channel)shapes. QA Inspector Brannon informed Task Leader Robert Cuellar and Task Leader Dave McClary of QA Inspector Brannon's findings. This discrepancy was discussed by Caltrans/ABF and ZPMC during today's issues meeting and it was agreed that such material could be used on the Tower Mock-Ups only and not for production.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brannon,Sherri
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert
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QA Reviewer
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